Work	Order II	59239
		,,

Friday, May 28, 2010 9:50:23 AM



Page 1

Item ID:

D4091-1

Accept

Setup Start



**Revision ID:** 

Item Name: Mounting Lug

Start Date: 5/27/2010 Required Date: 6/4/2010

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

**Process Plan:** 

Date: 125-28 Tooling:

Date: SPC (Y/N): Date:

Date:

Run

Start

Stop

Stop

Sequence ID/ Work Center ID

**Draw Nbr** 

Operation Description

**Revision Nbr** 

Set Up/ **Run Hours** 

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

D4091

Α

QC:

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 1.450" LONG

0.00

0.00 and 10/06/05

12 0

110

HAAS 1

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA920 AND DWG

FOLIO REV: DWG REV:

0.00

0.00

**DEBURR** 

Memo

## **Dart Aerospace Ltd**

W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								<del> </del>					
Part No	•	PAR #:	Fault Cate	gory:	NC	Date:	<u> </u>						
	PAR #: Fault Category:  Resolution: Disposition:  CR: WORK ORDER NON-CO			n:	QA	: N/C Cl	osed:		Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR	(1)			•			
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval			
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector				
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Work	Order	ID	59239	
work	Oraer	. 117	39239	

Friday, May 28, 2010 9:50:23 AM



Page 2

Item ID:

D4091-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name: Mounting Lug

5/27/2010

**Start Qty: 12.00** 

Req'd Qty: 12.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:	
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Process Plan:

Date: Tooling:

Date:

Run

Start



Required Date: 6/4/2010

Date:\_\_\_\_\_

SPC (Y/N):

Set Up/

Tool ID

Date:

Stop

Sequence ID/ **Work Center ID** 

120

Operation Description

QC2- Inspect parts off machine FAI/FAIB

**Run Hours** 0.00

0.00

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Insp. Number Stamp

Quality Control

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

MV= 100100

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

 $_{0.00}^{0.00} = 7 \, \text{m} \, 1 \, 10/06/07$ 



Dart Aerospace	e Ltd
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W/O:		WORK ORDER CHANGES								· · ·		
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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<del></del>												
Part No: PAR #:			Fault Cat	egory:	NCR	: Yes	os No DOA: Dato:					
Part No:  Resolution NCR:	solution:											
NCR:			WORK ORE	DER NON-CONFORM	ANCE	(NCR	)					
DATE	STED	Description of NC			tion B		Verific	ation	Approval	Approval		
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
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1000												

Work Orde Friday, May 28,									Pag	e 3
Item ID: Revision ID: Item Name:	D4091-1 Mounting Lug			ccept			Setup	Start Stop		
Start Date: Required Date: Reference:	5/27/2010 6/4/2010	<b>Start Qty:</b> 12.00 <b>Req'd Qty:</b> 12.00	† 1881) 1882 (1891) 1884) 1884 (1884)		Cust Item ID: Customer:					
Approvals:			<del></del>	Tooling:	Date:		Run	Start Stop		
Sequence ID/ Work Center II  150  Powdercoat  Powder Coating		White Gloss(Ref:4.3.5.1) per QS	1484 ( 1005 4.3-Alum 17:8:0024 2:3209-		Tool ID Tool#	Code Qty	pt Rej Qty	, N	Reject Insp. Number Stamp	_
160  QC  Quality Control		QC3- Inspect Part Finish  Memo		0.00		Ø_	L	L/O	-6-8.	_
170 Packaging		Identify as per dwg & Stock Loc.  Memo	ation: 57460	0.00		M	10-	6-9		_

Dart	<b>Aerospace</b>	Ltd	

W/O:			W	ORK ORDER CHANGI	ES		·		F
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:			Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
	Re	esolution:	Dispositi	on:	QA: N/C CI	osed:		Date:	
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B Sign 8		cation	Approval	Approval
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NOTE: D	ate & initia	l all entries							
H:\fFORMS\	Quality Assu	rance\approved QA\NCRWO RevE							
	1i	<del> </del>				<u> </u>			· <del></del>

#### **Picklist Print**

Friday, May 28, 2010 9:50:28 AM

Work Order ID: 59239

Parent Item Name:

D4091-1

Mounting Lug

Comments:

Parent Item:

IPP REV : A NEW ISSUE 10-03-31 JLM VERIFIED BY:EC

**Start Date: 5/27/2010** 

Required Date: 6/4/2010

Page 1

**Start Qty: 12.00** 

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	470.5321	0.1251	1.580211			

Lug Extrusion

Location Loc Oty Loc Code MAT06 470.5320795 43722 180 <del>-</del>▶ 45800 290.532079

1.5803 or Lidoldos

### **Dart Aerospace Ltd**

W/O:	PAR #: Fault Category:  Resolution: Disposition:  WORK ORDER N		ORK ORDER CHANG	ES				e C ,	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•						
Part No:	Part No:PAR #:Fault Category:		gory:	NCR: Yes	No DQ	A:	Date: _		
	Re	esolution:	Disposition	1:	QA: N/C C	losed:		Date: _	
NCR:		·	WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section C		Chief Eng	QC Inspector
Part No:Res			•						
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DART AEROSPACE LTD	Work Order: 59239	
Description: MOUNTING LUG	Part Number: D4091-1	
Inspection Dwg: D4091 Rev: A	Page 1 of 1	_

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing		A -41	T	<del></del>	<u> </u>	
Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	+/030	4.452	V			
1,38	+/030	1.378	ンシ			
RO.03-80.070	RO.03/RO.07U	0.063	/			
0270	+/030	0.271	V .			
0.293	+/010	6.293	~			
R1.20	+/030	R 1.20	V			
3.700	+/010	3.700	-			•
0.375	+/010	0.377	~			
0.625	+/010	0.625	~			
0.375	:+/010	0.377	~			
Ø0.257	+.006/001	Ø0.258	レ			
RO.34	+/030	RO.34	V			
2.310	+/010	2.309	V			
1.91	+/030	1.908	V			
0.69	+/030	0.685	/			
R 6.40	+/030	BO.400	~	,		
00.257	t.006/-,001	\$ 0.259	V			
35°	+/-1/20	350	V			
R 0.63	+/010	R 0.063	~			

Measured by: $\mathcal{H}$ A		Audited by:	mv	Prototype Approval:	N/A
Date: 10/06	106	Date:	10/06/06	Date:	N/A

Rev Date	Change	Revised by	Approved
A	New Issue	KJ/JLM	

**D4091-1 MOUNTING LUG** 

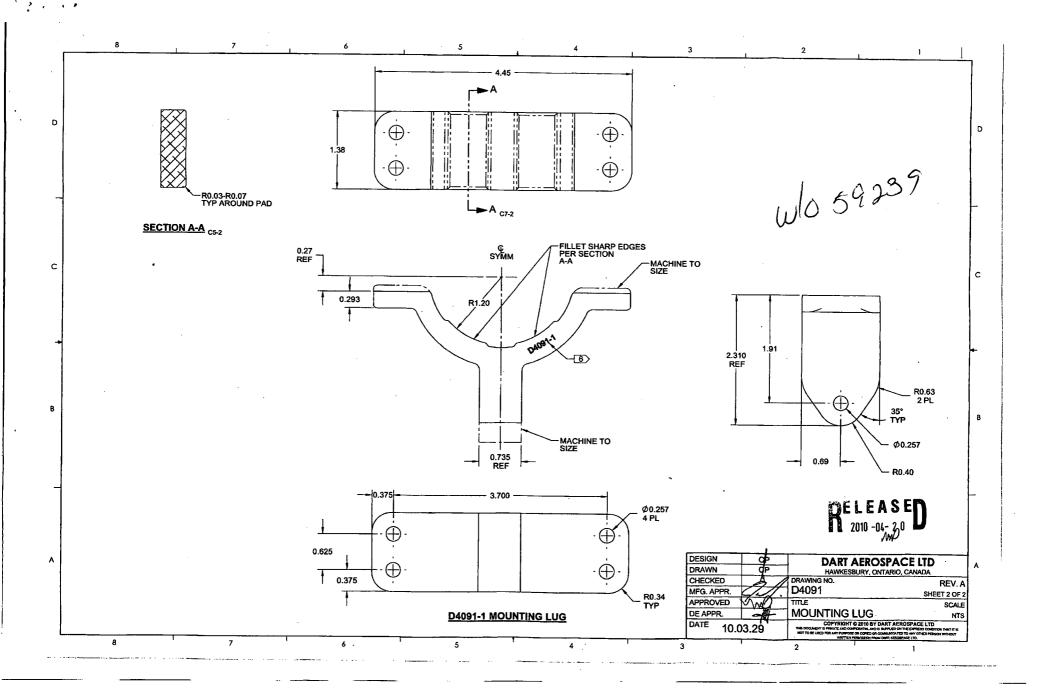
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 59237 NO. 5-28

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005

Α	NEW IS	SUE		CP	10.03.29		
REV.			DESCRIPTION	BY	DATE		
DESIG	4	C#	DART AEROSI	ACEL	תז		
DRAW	٧	CP-	HAWKESBURY, ONTARIO, CANADA				
CHECK	ED	31	DRAWING NO.		REV. A		
MFG. APPR.			D4091		SHEET 1 OF 2		
APPRO	VED	ANY	TITLE		SCALE		
DE APF	PR.		MOUNTING LUG		NTS		
DATE 10.03.29			COPYRIGHT © 2010 BY DAR THIS DOCUMENT IS PRIVATE AND CONFEDENTIAL WID IS BUT MUT TO BE USED FOR ANY PURPOSE OR COPED OR COMMA WINDTEN PROMISSION PROMISSIO	LED ON THE COPICS	S COMOTION THAT IT IS		

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES				3	, I , S					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:										
Resolution:									Date:			
NCR:			WORK OR	DER NON-COI	NFORMAN	CE (NCF	₹)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action De Chief	scription	Sign 8	k Sect	cation ion C	Approval Chief Eng	Approval QC Inspector		
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Dart Aerospace Li	td
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W/O:			WOF	K ORDER CHANG	ES				* * * *	
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Part No	:	PAR #:	_ Fault Catego	ry:	NCF	R: Yes N	o <b>DQA</b> :	Date:		
							osed: Date:			
NCR:		W	ORK ORDER	R NON-CONFORMA	NCE	(NCR)	•			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	on B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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